

Date: Monday, 6/18/2007 10:22:50 AM
 User: Eric Charbonneau

Process Sheet



Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LEG
 Job Number : 32917
 Estimate Number : 12907
 P.O. Number : N/A Part Number : D35233
 This Issue : 6/18/2007 S.O. No. : N/A Drawing Number : D3523 UNDER REVIEW
 Prsht Rev. : NC Project Number : IA0001
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : N/A
 Previous Run : N/A Material : N/A
 Written By : EC Due Date : 6/19/2007 Qty: 4 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-06.15 EC

Additional Product

POSITIVE RECALL

EFFECTIVE 07-06-18 AUTH ll

RELEASED _____ DATE _____

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6R0750

6061-T6 Round Bar .750"



Comment: Qty.: 0.0945 f(s)/Unit Total : 0.3780 f(s)
 6061-T6 round bar 0.750"
 (M6061T6 round bar 0.750")
 Batch: 103857

EC 07-06-18

2.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
 Turn as per Dwg D3523

EC 07-06-18

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EC 07-06-18

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EC 07/06/18

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

M.H. 07/06/19

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A

4x

Date: Monday, 6/18/2007 10:22:50 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 32917

Part Number: D35233

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



For 06.20 (4)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1

Not Required



ENG APPROVAL



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *1/5*

CB 07.06.21



9.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/26

Job Completion



U 07.06.26

POSITIVE RECALL

ECTIVE

AUTH

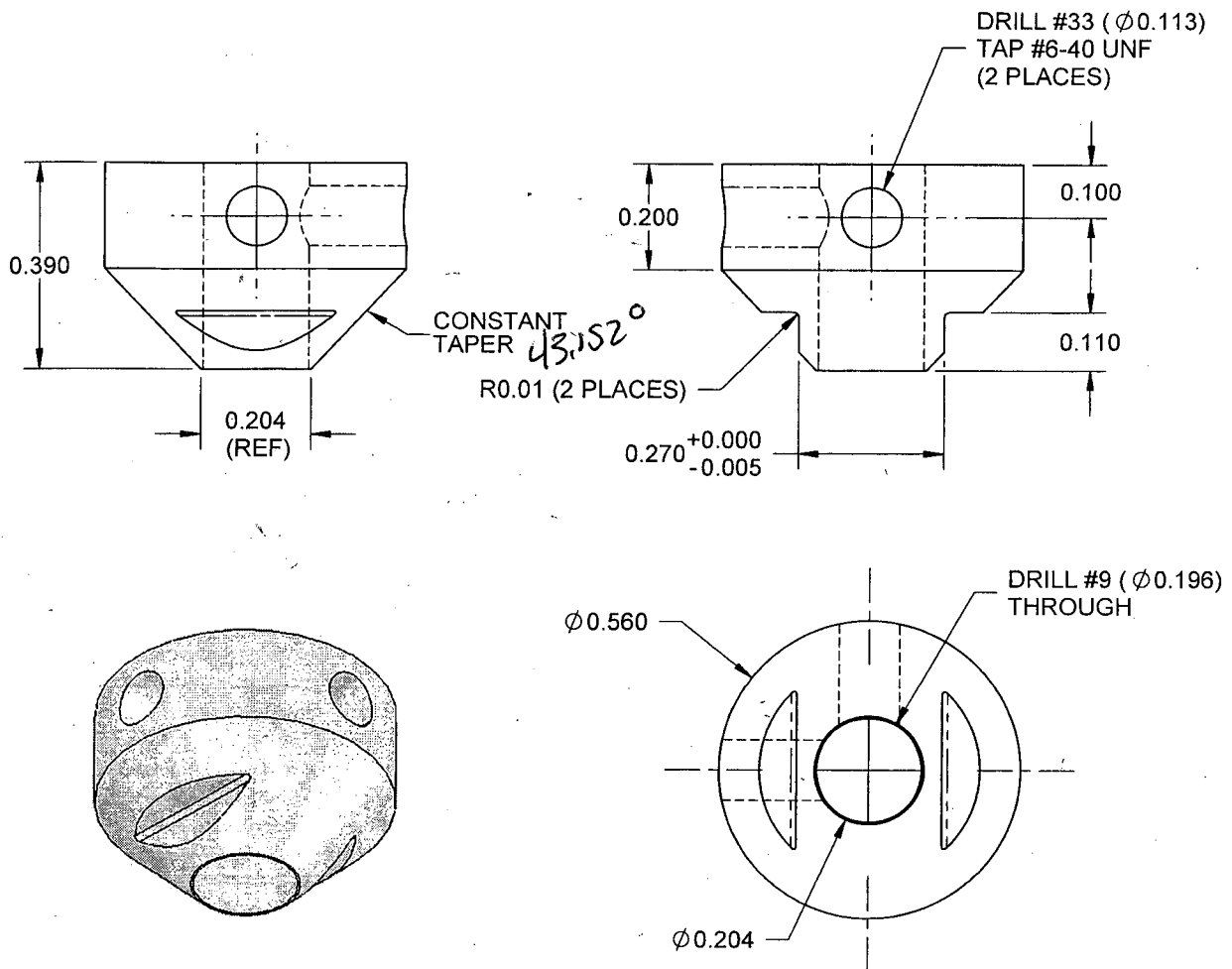
LEASED

DATE

07.06.26

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3523	REV. A SHEET 2 OF 2
DATE 07.06.14	TITLE LEG		SCALE 3:1



D3523-3 LEG

PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

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DART AEROSPACE LTD		Work Order: 32917
Description:		Part Number: D3523-3
Inspection Dwg: D3523	Rev: U/R	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.100	±0.01	0.103	✓			
B 0.110	±0.01	0.111	✓			
C 0.270	+0.000 -0.005	0.2676	✓			
D φ.113	+0.005 -0.001	φ.115	✓			
E φ.196	+0.006 -0.001	φ.199	✓			
F 0.390	±0.01	0.390	✓			
G 0.200	±0.01	0.210	✓			
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>EE</i>	Audited by: <i>EP</i>	Prototype Approval:	N/A
Date: 07.06.18	Date: 07/06/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	